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(54) **METHOD FOR CONTROLLING
TEMPERATURE AT LOWER SIDE OF NECK
PORTION DURING PRE-FORM MOLDING,
AND CORE MOLD**

the lower side of the place approximately equal to that of the barrel side.

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(57) Abstract:

PROBLEM TO BE SOLVED: To prevent the occurrence of banks at the lower side of a bottle neck portion formed by orientation blow molding by controlling cooling at a place in which the lower side of a neck portion of pre-form is molded in a core mold in case of releasing the pre-form at an earlier stage.

SOLUTION: A step portion 34 is formed in the interior portion at a boundary place between the cavity mold 1 and the neck mold 2 of a core mold 3 piercing the neck mold 2 and situated within the cavity mold 1. A wall thickness ring-like piece 5 consisting of low heat conductive material is fitted in the step position 34 in order to interrupt the boundary place of the cavity 1 and the neck mold 2 of the core mold 3 and the interior cooling path 36 in thermally conductive relation, thereby controlling a distribution of the temperature at the lower side of the pre-form neck portion molded at

